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PLOT SCALE:

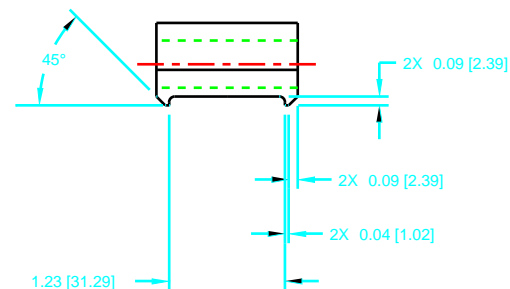
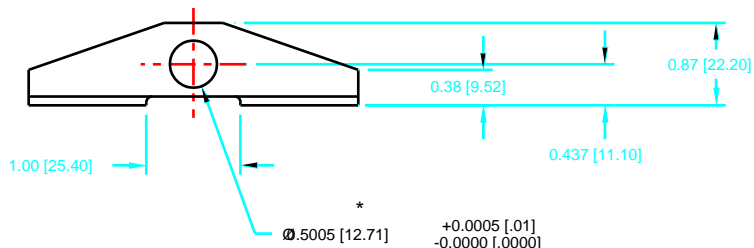
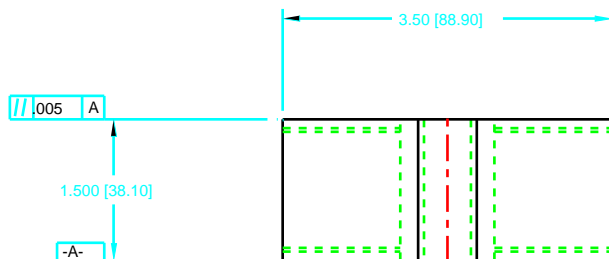
DWG. SCALE:

4

3

2

1



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS

* HOLE IS TO BE LOCATED AND DRILLED AFTER PART IS WELDED IN ASSEMBLY P41020101-210000-01
SHEET 1 OF 2

2	REDESIGNED	M.J.M.			
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE	
REVISIONS					

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS ANGULAR				
.X - .03 - .25				
.XX - .01				
.XXX - .005				
SURFACE ROUGHNESS 125 ✓				
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER A17157		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DRAWN BY MUSCIA	DATE 8/3/92	CHIEF DESIGN ENGINEER D. SHU	DATE 6/15/93	TITLE ADVANCED PHOTON SOURCE P1 1-ST PHOTON SHUTTER SUPPORT STRUCTURE CLEVIS
CHECKED BY		GP LEADER T.M. KUZAY	DATE 6/15/93	
DESIGNER SHU/MUSCIA	DATE 6/15/93	PROJECT MGR.		
RESPONSIBLE ENGINEER D. SHU	DATE 6/15/93	APPROVED/RELEASED		
MATERIAL 316 STAINLESS STEEL		SCALE 1:1	SIZE C	DRAWING NUMBER P4102010103-210503-02
		SHEET 1 of 1		